

Work Order ID 71181

Thursday, June 23, 2011 11:16:28 AM



Page 1

Item ID:	D3965-4	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Bearing, Spherical					
Start Date:	6/23/2011	Start Qty:	12.00		Cust Item ID:	
Required Date:	6/30/2011	Req'd Qty:	12.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>11/06/23</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3965	Rev A								

100

Purchasing
Purchasing
Memo
PURCHASING
Issue P/O: 14359
Purchase Part Number: 63215K32 or 63215K52
Possible Supplier: McMaster
Material release note is required

0.00

0.00

CL 11/06/23 (12)

110

Packaging
Packaging
Memo
Receive & Inspect for Damage & Mat'l Certs

0.00

0.00

CL 6/23/2011 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71181

Thursday, June 23, 2011 11:16:28 AM



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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00		5 u06/28		(42)			
130 Packaging Packaging	Identify as per dwg & Stock Location: ST 100 Memo	0.00 0.00				JB	(12)		11/06/29
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							n/6/29

11-06-29
(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 23, 2011 11:16:25 AM

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T

Work Order ID: 71181



Parent Item: D3965-4



Parent Item Name: Bearing, Spherical



Start Date: 6/23/2011

Required Date: 6/30/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
63215K32  Spherical Bearing		Purchased	No			110	Each	0.0000	1 	12		<i>Pick/22 (12)</i>	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

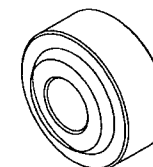
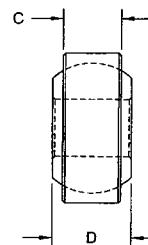
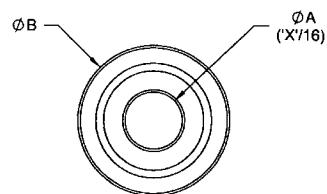
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71181

CL1106123

D3965-X BEARING, SPHERICAL

WHERE 'X' IS I.D. IN 1/16" OF AN INCH
EG Ø 1/4" (4/16") I.D. BEARING = D3965-4

DART P/N	SUPPLIER	SUPPLIER P/N	A	B	C	D	STATIC RADIAL LOAD CAP. lbs
D3965-3	McMASTER-CARR	63215K31	0.188	0.563	0.281	.219	3,975
D3965-4	McMASTER-CARR	63215K32 OR 63215K52	0.250	0.656	0.344	0.250	6,040
D3965-5	McMASTER-CARR	63215K53	0.313	0.750	0.375	0.281	8,750
D3965-6	McMASTER-CARR	63215K34	0.375	0.813	0.406	0.313	10,540

RELEASED
09/08/25

NOTES:

- 1) MATERIAL: 440C STAINLESS STEEL WITH PTFE LINER
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

A		NEW ISSUE		RF	09.07.09
REV.	DESCRIPTION			BY	DATE
DESIGN	RF	DART AEROSPACE LTD			
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA			
CHECKED		DRAWING NO.	D3965	REV. A	
MFG. APPR.		TITLE	BEARING, SPHERICAL	SCALE	NTS
APPROVED		SHEET 1 OF 1			
DE APPR.		DATE 09.07.09			
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO14359

Purchase Order Date 6/23/2011

PO Print Date 6/23/2011

Page Number 2 of 2

Order From :

VU-MCM001

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	330 995 5500	Requisition Nbr	
Vendor Fax	330 995 9600	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	USD
		FOB	Destination-Collect

4	6605K56	HOOK AND LOOP TIE	6/27/2011	25.00	Purolator ground	\$2.7780	\$69.45
			Yes	Each			

Special Inst: AS PER DWG D3551 REV. A
B71167
MCMaster P/N: 6605K56

5	63215K52	Bearing Spherical	6/27/2011	12.00	Purolator ground	\$10.7500	\$129.00
			Yes	Each			

Special Inst: AS PER DWG D3965 REV. A
B71181
MCMaster P/N: 63215K52

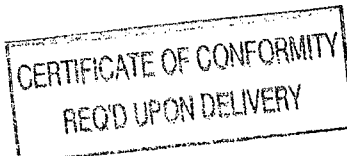
6	7510A653 10CC PLASTIC SYRINGES		6/27/2011	10.00	Purolator ground	\$8.3900	\$83.90
			Yes	Each			

Deliver To: FINISHING

7	7630A43 2' HIGH TEMP. TAPE		6/27/2011	8.00	Purolator ground	\$12.1800	\$97.44
			Yes	Each			

Deliver To: FINISHING

PO Total: \$515.50



Change Nbr: 1

Change Date: 6/23/2011

No substitution or deviation without consent.
Certificate of Conformity or Material Certification required when applicable

Purchase Order
PO14359

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00 Aurora Industrial Parkway
Aurora OH 44202
30-995-5500
le.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

McMaster-Carr Number
8537303-01

06/23/2011

Line	Description	Ordered	Shipped
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63215K52	Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 1/4" ID, 21/32" OD, 11/32" Overall Width	12 Each	12
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Unit Price: \$15.62
Extended Price: \$187.44

8 1466/28

7510A653	Plastic Syringe, with Luer Lock Connection, .34 oz Capacity, Packs of 10	10 Packs	10
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Unit Price: \$10.35
Extended Price: \$103.50

7630A43	High-Temperature Polyester Masking Tape, 2" Wide X 18 Yards Long	8 Rolls	8
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Unit Price: \$13.62
Extended Price: \$108.96

LNS A83

3 - 483

5

1 - 482

6

1 - 462

7

arges for this shipment

Merchandise Amount: \$593.37

Sales Tax: \$29.68

Total: \$623.05